

Date: Tuesday, 16/09/2008 1:22:17 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 42028		
Estimate Number	: 11178		
P.O. Number	:	Part Number	: D32931
This Issue	: 16/09/2008 S.O. No. :	Drawing Number	: D3293 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 41794	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JLD 08.9.16</u>		
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 1.9177 sf(s)/Unit Total : 23.0126 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
 (M2024T3S.080)  
 Identify for D3293-1  
 Batch: 109424 IB 8-9-30

(12)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3293  
 Dwg Rev: A  
 Prog Rev: A

IB 8-9-30

2-Deburr if necessary

IB 8-9-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-9-30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/09/30 ER2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 16/09/2008 1:22:17 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 42028

Part Number: D32931

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Deburr

u/a Done at Step #22  
8/8/30

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8/30 (12)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

ell 08-10-02 (X12)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 105 642 (12X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00  
05  
320  
12:30

M. 1 08/10/03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/03 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location:

8/10/06 (12)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



u 08.10.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_



Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

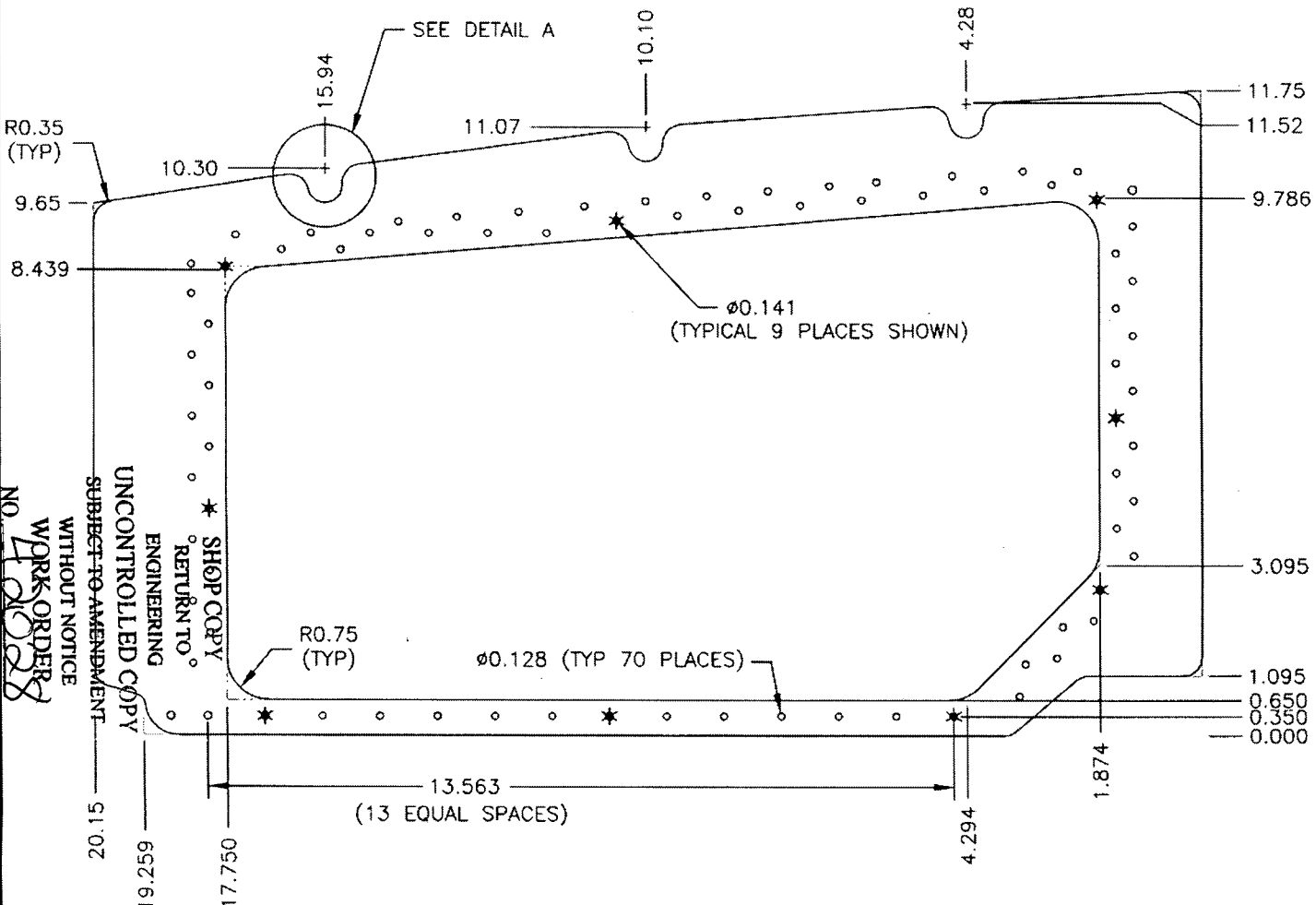
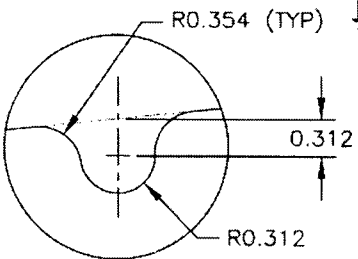


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DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A	
		D3293		SHEET 1 OF 1	
DATE		TITLE		SCALE	
04.06.28		DOUBLER		1:3	
A	04.06.28	NEW ISSUE			

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12



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WITHOUT NOTICE  
WORK ORDER  
NO 42028